

Work Order ID 110393-25PLIT

110393

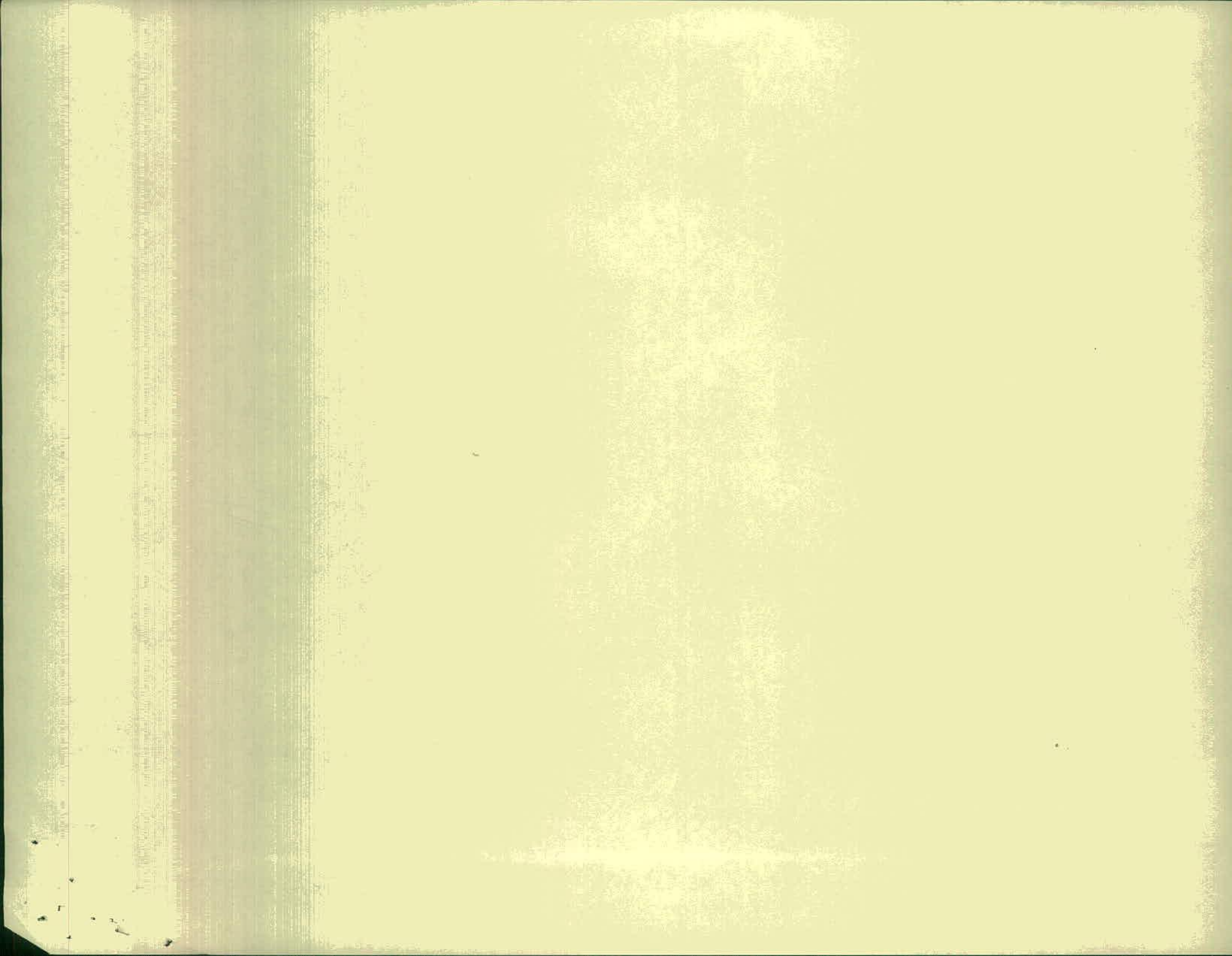
Page 1

December-18-13 8:49:57 AM

Item ID: D4634-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft, Center Ceiling Panel
 Start Date: 12/18/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 12/31/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 13-12-18 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4634	<u>PEJ</u> <u>27</u> <u>9-89</u> <u>per ECN 459</u>	0.00							
100	HAND FINISHING THERMOFORMING	0.00				<u>2</u>	<u>3</u>		<u>DL</u> <u>13/12/19</u>
100	Thermoform	0.00							
Thermoforming Machine	Memo Cut Blanks								
105	Dry Material	0.00				<u>2</u>	<u>3</u>		<u>DL</u> <u>13/12/19</u>
105	HandThermo	0.00							
Hand Finishing Thermoforming	Memo Dry Sheet as per OSI022 POLYCARBONATE Temp: <u>245°C</u> Time IN: <u>700 am</u> <u>13/12/18</u> Time OUT: <u>700 am</u> <u>13/12/19</u>								



December-18-13 8:49:57 AM

Page 2

[illegible]

Work Order ID 110393

December-18-13 8:49:57 AM

110393

Page 3

Item ID: D4634-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft, Center Ceiling Panel
 Start Date: 12/18/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 12/31/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

9-89

13/12/13

14/1/16

0.00

Memo

DAS

27

9-89

160

160

Packaging

Packaging

Packaging

Memo

0.00

0.00

USED ON W/O B111158

① SAO 1/4/01/17

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

POSITIVE RECALL

EFFECTIVE 1/10/22

RELEASED DATE

LC

MCS 14-1-23

11-3-23

~~RD43977A~~

POSITIVE RECALL

EFFECTIVE 1/3/22

RELEASED DATE

LC

mf 14-1-17

Release Dwg Rev E

DAS

27

9-89

14-1-23

Picklist Print

Page 1

December-18-13 8:50:01 AM

Work Order ID: 110393

110393

Parent Item: D4634-5

D4634-5

Parent Item Name: Aft, Center Ceiling Panel

Start Date: 12/18/13

Required Date: 12/31/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev. A New Issue 12/05/07 DL VERIFIED BY:JLM
B Dwg. Update 13/07/09 DL verf:DD
Update, Material Change 13/12/18 DL

IPP Rev.
IPP Rev C Dwg.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MLEXS.093-F6006-07

Purchased

No

100

sf

1,838.000

12.93

31

MI FXS 093-F6006-07

**

31

BD 13/12/23

GE PLASTICS LEXAN SHEET

Location

Loc Qty

Loc Code

MAT023

2067.26

114459

229.26

123105

38

124501

1800

DART AEROSPACE LTD	Work Order: 110393
Description:	Part Number: D4634-5
Inspection Dwg: D4634 Rev: PD2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>W.H.</u>	Date: 14/01/15
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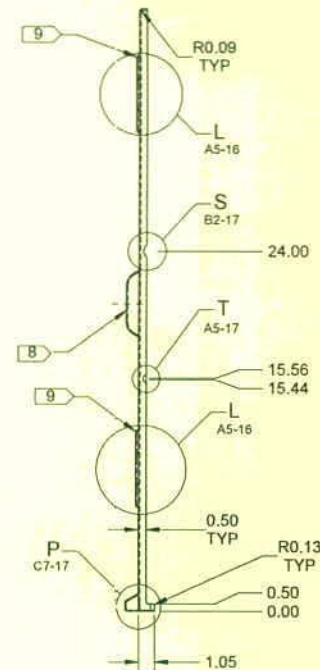
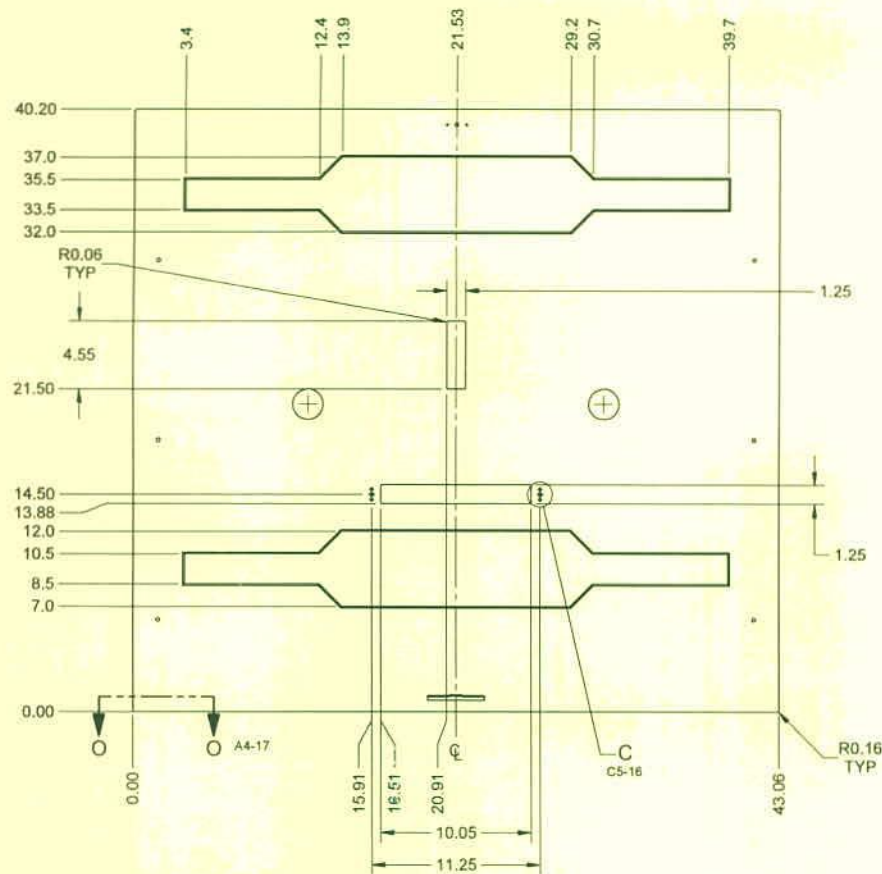
TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.20"		40.22"	✓			
43.06"		43.06"	✓			
1.05"		1.057"	✓			
0.50"		0.502"	✓			
10.05"		10.05"	✓			
1.25"		1.25"	✓			
4.55"		4.55"	✓			
1.25"		1.25"	✓			
Ø 2.03		2.00"	✓			
Ø 0.25"		0.25"	✓			

Measured by: DAS <u>27</u> <u>W.H.</u>	Date: 14/01/15
Audited by: 9-89	Date: 14/1/15
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14



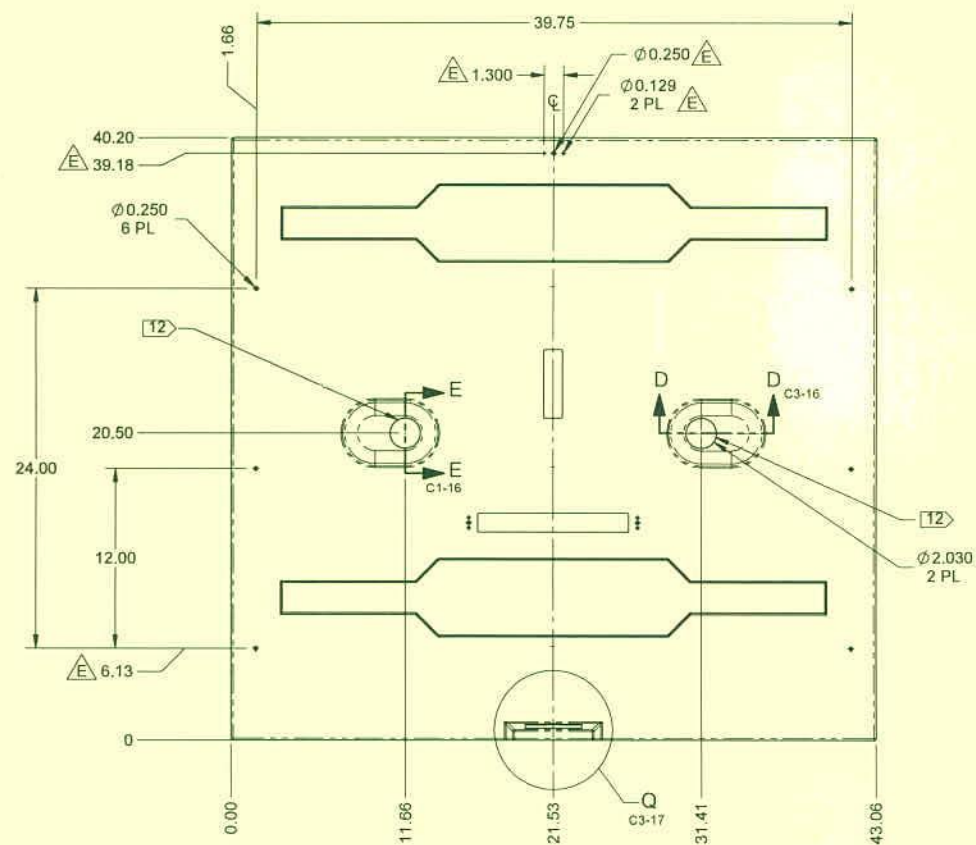
NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.39 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-5 PER TOOL DT9838
- 11) THERMOFORM PER QSI 022 USING DT9846 TOOL
MIN. THICKNESS AFTER FORMING:
EDGES = 0.060
ELSEWHERE = 0.070
- 12) LOCATE $\phi 2.030$ AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 14 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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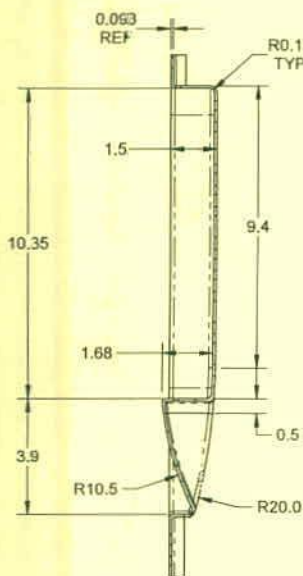




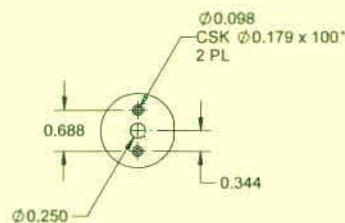
D4634-5 AFT, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 15 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	NTS
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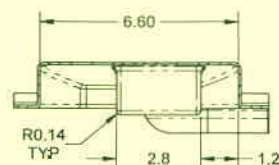




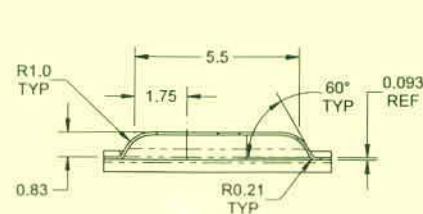
SECTION G-G C5-11
SCALE 4X



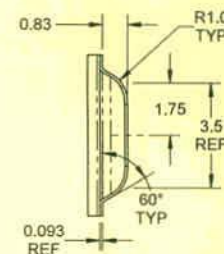
DETAIL C B7-10
SCALE 4X B4-12
B4-14



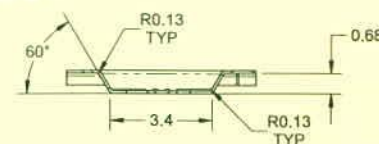
SECTION H-H C5-11
SCALE 2X



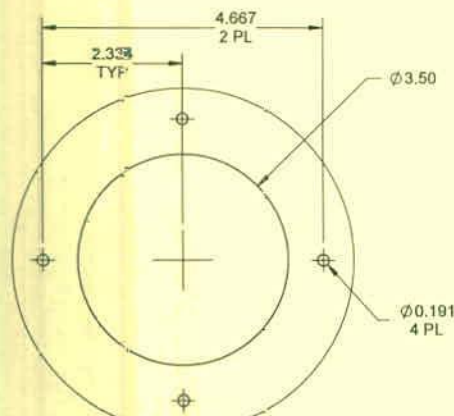
SECTION D-D B6-11
SCALE 2X C4-13
C4-15



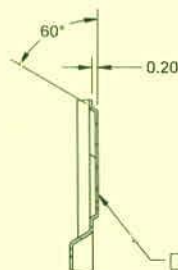
SECTION E-E B5-11
SCALE 4X C4-13
C5-15



SECTION J-J B6-13
SCALE 2X

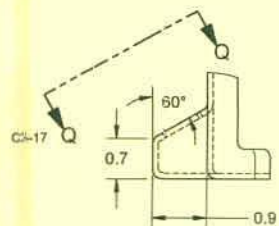


DETAIL B B7-10
SCALE 4X
2 PL

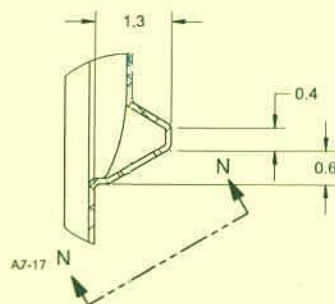


DETAIL I B2-13
SCALE 4X C2-13
TYP B2-14
C2-14

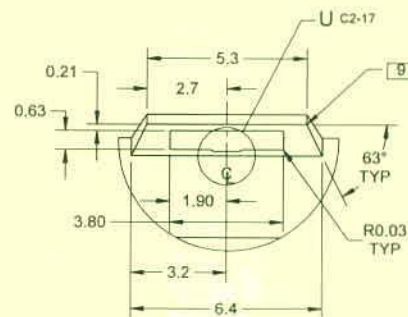
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DRAWN	RF		
CHECKED	<i>SC</i>	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 16 OF 17
APPROVED		TITLE	SCALE
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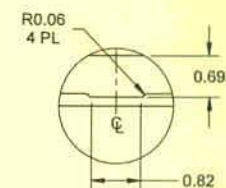
DETAIL P B3-14
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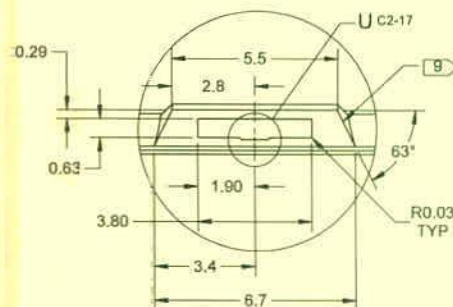
DETAIL M C3-10
SCALE 2X



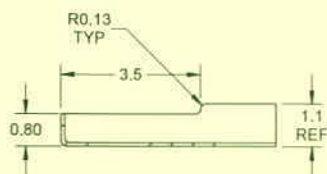
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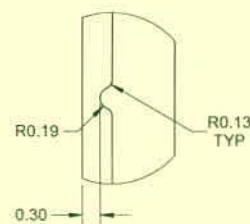
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SCALE 0.5X



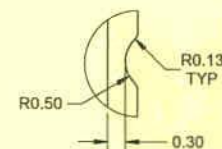
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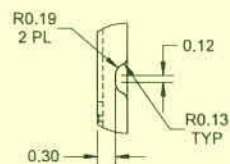
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10
SCALE 4X



DETAIL S B3-10
SCALE 4X



DETAIL T C2-14
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	SC	DRAWING NO.	REV. PE1
MFG. APPR.		D4634	SHEET 17 OF 17
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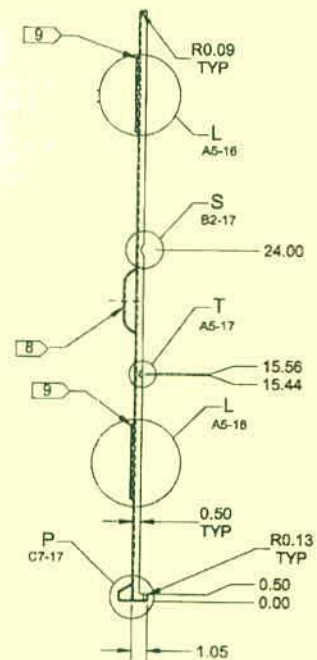
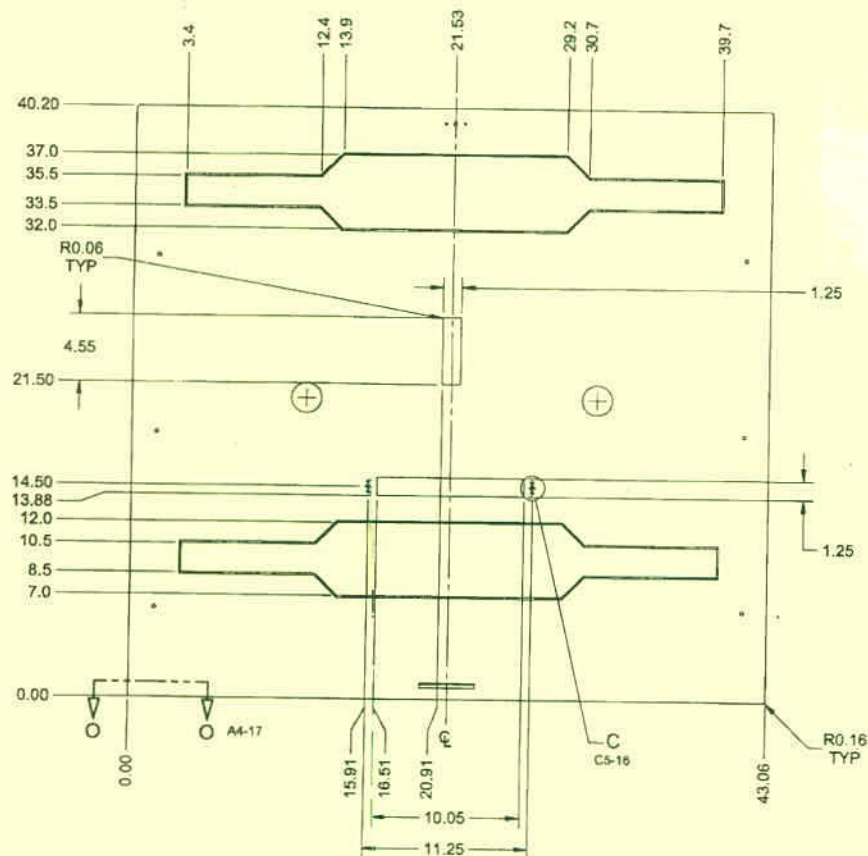


Description: <u>alt Center Panel</u>	Work Order: <u>B110393</u>
Inspection Drawing: <u>D4634</u>	Rev: <u>PEI</u> Part Number: <u>D4634-S</u>

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.4	± 1.03	3.41	✓		T	T QCI-13
12.4	"	12.40	✓		T	T "
13.9	"	13.9	✓		T	"
21.53	"	21.54	✓		T	"
29.2	"	29.2	✓		T	"
30.7	"	30.7	✓		T	"
39.7	"	39.7	✓		T	"
43.06	"	43.08	✓		T	"
10.05	"	10.05	✓		T	"
11.25	"	11.25	✓		T	"
7.00	"	7.00	✓		T	"
8.05	"	8.08	✓		T	"
10.5	"	10.08	✓		T	"
12.0	"	12.00	✓		T	"
13.88	"	13.90	✓		T	"
14.00	"	14.00	✓		T	"
21.00	"	21.00	✓		T	"
4.50	"	4.50	✓		T	"
32.00	"	32.00	✓		T	"
33.5	"	33.50	✓		T	"
35.5	"	35.00	✓		T	"
37.0	"	37.00	✓		T	"
40.00	"	40.20	✓		T	"
1.25	"	1.20	✓		T	"
24.00	"	24.00	✓		T	"
12.00	"	12.00	✓		T	"
11.66	"	11.70	✓		T	"
21.33	"	21.50	✓		T	"
31.41	"	31.40	✓		T	"
43.00	"		✓		T	"
13.00	"	13.00	✓		T	"
39.75	"	39.75	✓		T	"
8.250	"	8.25	✓		T	"
8.191	"	8.193	✓		T	"

Measured by: <u>DAS</u> <u>27</u> <u>9-89</u>	Checked By:	QC inspector:	Engineering Approval (if necessary):
Date: <u>14/1/16</u>	Date:	Date:	Date:



NOTES:

1) MATERIAL: F6086 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
(REF DART SPEC MLEXS.093-F6006-07)

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 7.39 lbs

8) TEXTURE ON THIS SIDE

9) 0.14 RADIUS NOT SHOWN FOR CLARITY

10) DRILL & TRIM D4634-5 PER TOOL DT9838

11) THERMOFORM PER QSI 022 USING DT9846 TOOL

MIN. THICKNESS AFTER FORMING:

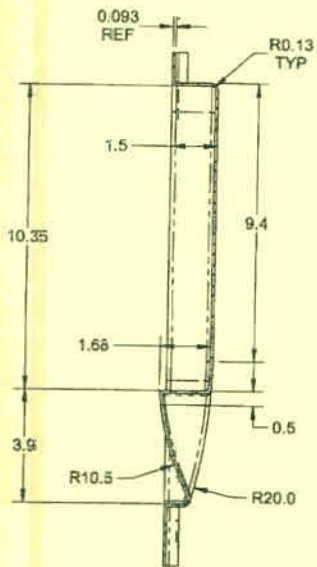
EDGES = 0.060

ELSEWHERE = 0.070

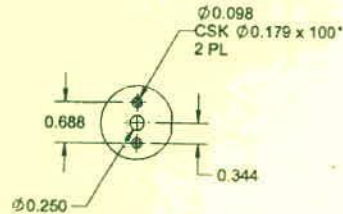
12) LOCATE Ø2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-5 AFT, CENTER CEILING PANEL

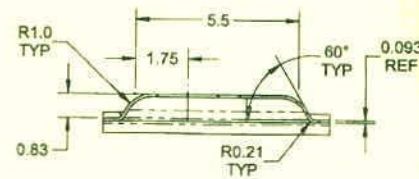
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 14 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
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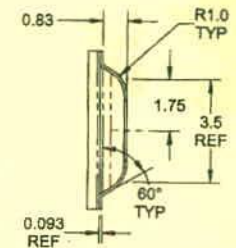
SECTION G-G C5-11
SCALE 4X



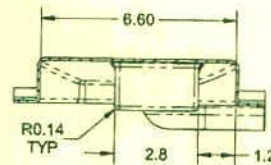
DETAIL C B7-10
SCALE 4X B4-12
B4-14



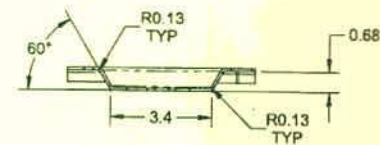
SECTION D-D B6-11
SCALE 2X C4-13
C4-15



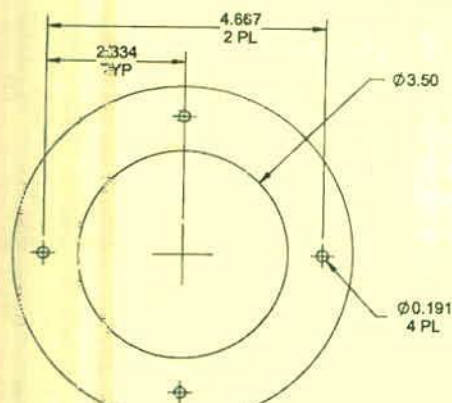
SECTION E-E B5-11
SCALE 4X C4-13
C5-15



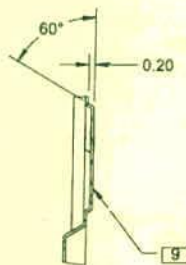
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X

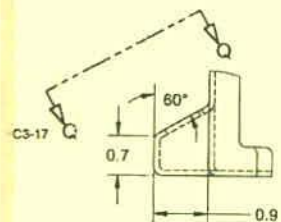


DETAIL B B7-10
SCALE 4X
2 PL

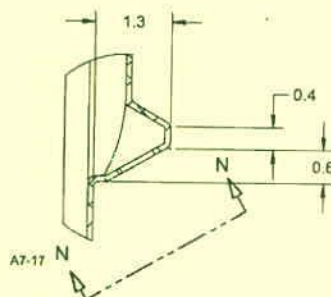


DETAIL I B2-13
SCALE 4X C2-13
C2-14
TYP

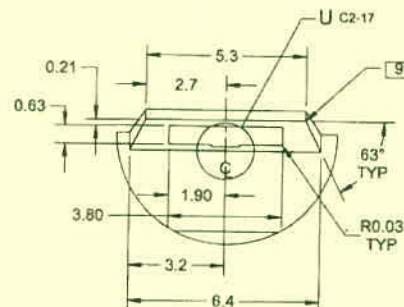
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. E
MFG. APPR.	PC	D4634	SHEET 16 OF 17
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	CENTER CEILING PANELS	NTS
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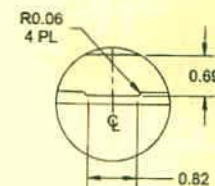
DETAIL P
SCALE 2X B3-14



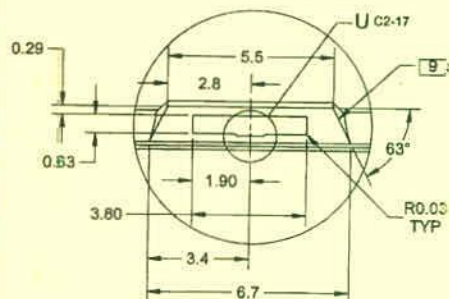
DETAIL M
SCALE 2X C3-10



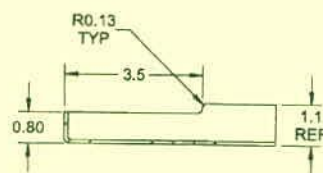
DETAIL Q
SCALE 0.5X B4-15
D8-17



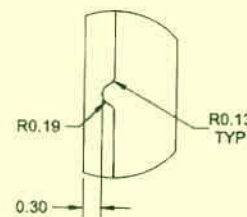
DETAIL U
SCALE 0.5X B7-17
D3-17



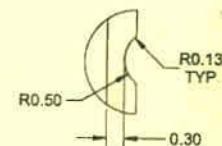
DETAIL N
SCALE 0.5X C5-17
B4-15



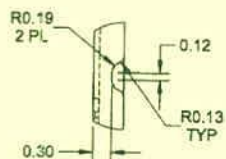
SECTION O-O
SCALE 1.3X B8-14



DETAIL R
SCALE 4X B3-10
C3-10
B2-12



DETAIL S
SCALE 4X B3-10
C2-12



DETAIL T
SCALE 4X C2-14

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